

Work Order ID 157966

Monday, March 06, 2017 1:47:50 PM

157966

Page 1

Item ID: D2182B035 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Clamp Cushion Black 3.5" Long
Start Date: 3/6/2017 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 3/7/2017 Req'd Qty: 50.00 ***50*** Customer:
Reference: SCHEDULED

Approvals: Process Plan: DAS Date: MAR 06 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 21 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***
9-89

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2182	Rev C

100	Packaging	0.00				<u>50</u>			
100									
Packaging	Memo	0.00					<u>DAS</u>		<u>MAR 06 2017</u>
Packaging	Cut as per dwg						<u>6</u>		
							<u>9-89</u>		

110	QC6- Inspect dimensions to drawing	0.00							
110									
QC	Memo	0.00				<u>50</u>			<u>MAR 06 2017</u>
Quality Control								<u>DAS</u>	<u>38</u>
								<u>9-89</u>	

120	Identify as per dwg & Stock Location: <u>5003</u>	0.00							
120									
Packaging	Memo	0.08				<u>50</u>			<u>MAR 06 2017</u>
Packaging							<u>DAS</u>		
							<u>6</u>		
							<u>9-89</u>		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
☐ Environment	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
☐ Design	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
☐ Doc/Data	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
☐ Equip/Tooling	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
☐ Handling/Pre	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
☐ Material	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
☐ Internal Transport	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
☐ Tribal Knowledge	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
☐ LOA	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
☐ Substation	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
☐ Past Expiry Date	☐ Manufacturing Process	OTHER : _____					
☐ Misidentified	☐ Past Due						

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.83							
Quality Control									

17/3/6 
DAS
21
9-89 MAR 06 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																														
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Misidentified ☐	Past Due ☐																																																																	

Picklist Print

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Page 1

Work Order ID: 157966

157966

Parent Item: D2182B035

D2182B035

Parent Item Name: Clamp Cushion Black 3.5" Long

Start Date: 3/6/2017

Required Date: 3/7/2017

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: B99.03.02Reformat DM
as per revC DD verf:EC

IPP Rev:C 10.11.02

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2182B		Manufactured	No			100	f	125.6850	0.2916	14.58			
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D2182B

Rubber Cushion - Black (\$Per Foot)

DAS
6
9-89

MAR 06 2017

Location

Loc Qty

Loc Code

ST411

125.685

135093

125.685

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

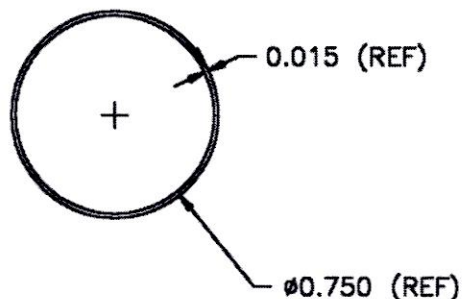
QA Closed: _____ Date: _____

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3				Lead hand / Supervisor Approval Verification	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

RELEASED
97/05/16 DS

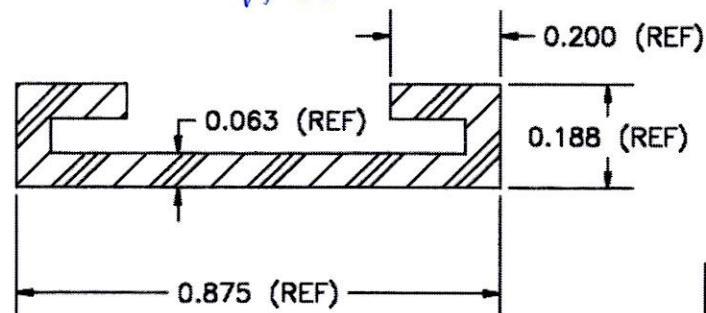
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 157966 *MC5*
1703-06



D2182-050 HEAT SHRINK
LENGTH

EG: 3.5 LONG: D2182-035
10 LONG: D2182-100

MATERIAL: RAYCHEM RNF-100-3/4-CL
HEAT SHRINKABLE INSULATION SLEEVING



W-WHITE
B-BLACK
D2182W050 RUBBER CUSHION
LENGTH

EG: WHITE 3.5 LONG: D2182W035
BLACK 10 LONG: D2182B100

MATERIAL: SANTOPRENE 101-73
CONFORMS TO MIL-R-3065

DART



C	97:05:14	ADD HEAT SHRINK	RUBBER CUSHION	D2182	TITLE	RUBBER CUSHION	REV. C	SHEET 1 OF 1	SCALE	DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	PREPARED <i>KE</i>	CHECKED <i>DM</i>	APPROVED <i>BOB</i>	DATE Jan. 6, 1995
B	97:04:07	ADD MATERIAL SPECIFICATION												

DQA: _____ Date: _____



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OTHER : _____					